

Date: Thursday, 4/12/2007 9:00:12 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: D119 HELI UTILITY BASKET PRELIM
Job Number	: 31751		
Estimate Number	: 12452		
P.O. Number	: <i>N/A</i>	Part Number	: D119756041
This Issue	: 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: IIN-D119-756 PG11-12
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: C
Previous Run	: 31750	Material	: <i>N/A</i>
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>H 07.04.12</i>		
Comment	: Est Rev: A New Issue 06-06-14 JLM Est Rev. B 06.07.26 dwg revB, picklist EC est rev C revC dwg 07.04.09 EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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Comment: Photocopy bluefile & type labels per PPPD119-756-041 CHG 001

07-05-10 (1)

2.0	31751A	BASKET LID ASS'Y (A119)
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ml 07/05/17

Comment: Sub-Component BASKET LID ASS'Y (A119) SUB-COMPONENT

3.0	31751B	BASKET BASE ASS'Y (A119)
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ml 07/05/17

Comment: Sub-Component BASKET BASE ASS'Y (A119) SUB-COMPONENT

4.0	D2022101	Spacer
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer

Batch: *1330543*

5.0	D2258220	Placard
-----	----------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: *1324871*

6.0	D2332041	Lid Prop Assembly 6.69"
-----	----------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Lid Prop Assembly 6.69"

Batch: *1330547*

7/5/18 SQ

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:00:12 AM

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31751

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Handle Weldment

Batch: 1530383

8.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spring

Batch: 1528363

9.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bushing

Batch: 1531107

10.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bumper

Batch: 1521139

11.0

D35191

placard



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

placard

Batch: 1529576

12.0

AN316A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 1101884

13.0

AN47A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: 11100323 MIL 149

7/5/18 SP

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 31751

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

14.0

AN422A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M100771

15.0

AN424A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Bolt

Batch: M101938

16.0

AN517A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M102140

17.0

AN960JD416

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M102929

18.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M103962

19.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M103641

20.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

Batch: M103585

7/5/1859

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31751

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Washer

Batch: M103344

22.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cherry Rivets

Batch: M101519

23.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Nut

Batch: M103585

24.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M102552

25.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Nut

Batch: M5259

7/5/18 SC

26.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble as per Dwg D119-756

M107/05/18 ^{XL}

27.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07/05/18

①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31751

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Pick Packing Kit

29.0

D119756011

CLAMP KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
CLAMP KIT
Batch: _____

Handwritten signature/initials

30.0

D26173

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bushing

Handwritten: 1539991 X

31.0

D26175

Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Spacer

Handwritten: 1531756 X

32.0

D351611

CLEVIS



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
CLEVIS
batch: *Handwritten: 1530910 X*

33.0

D35171

STRUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
STRUT
Batch: *Handwritten: 1529574 X*

34.0

D3518041

STRUT ASSEMBLY



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
FWD ARM ASSEMBLY
Batch: *Handwritten: 1529575 X*

Handwritten: 7/5/1859

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:00:13 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31751

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

D35201

SPACER



1329578 ✓



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
SPACER

36.0

AN413A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
Batch: M103947 ✓

37.0

AN415A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
Bolt
Batch: M104072 ✓

38.0

AN420A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M16895 ✓

39.0

AN510A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Bolt
batch: M102959 ✓

40.0

AN960JD416

Washer



Comment: Qty.: 40.0000 Each(s)/Unit Total : 40.0000 Each(s)
Washer
Batch: M102929 ✓

41.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
Washer
M103962 ✓

7/5/18 SQ

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 21/03/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:00:13 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: D119 HELI UTILITY BASKET PRELIM

Job Number: 31751

Part Number: D119756041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

AN960JD516L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Washer *M17619 ✓*

43.0

MS21042L4

Nut



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
Nut
Batch: *M102552 ✓*

7/5/18 SQ

44.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

6/7/05/18 (1)

6/7/05/18 (1)

45.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and pack for shipping as per PPP D119
Location: *B*
PPP Rev: *B*

6/7/05/18 (1)

SQ

46.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/07/05/18

Job Completion



U of B. 18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

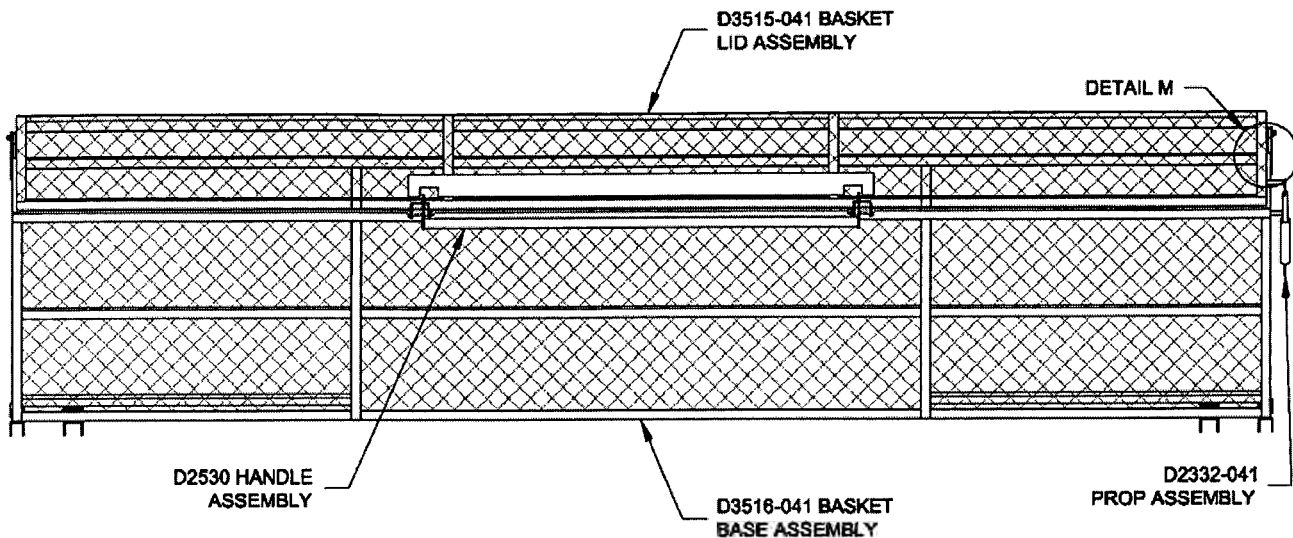
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

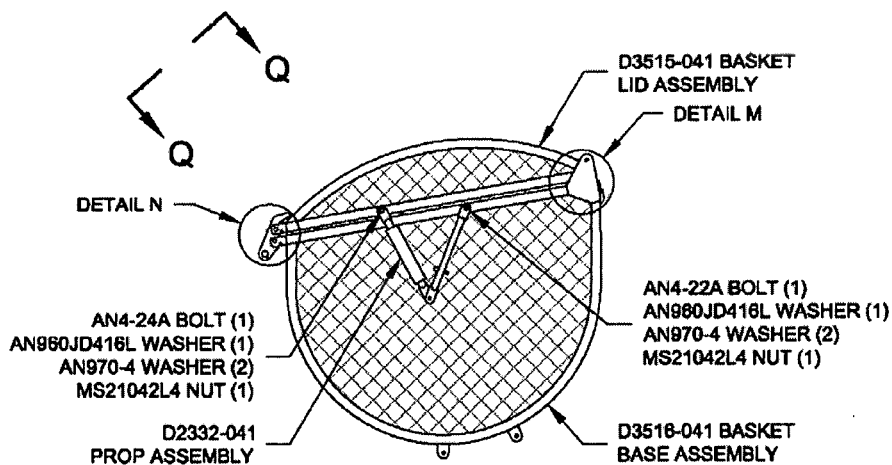
NOTE: Date & initial all entries

4.0 REPLACEMENT PARTS

Figures 4 and 5 list components of the Dart **Heli-Utility-Basket™** which can be replaced if required. Their part numbers are included for reference only, and are normally included with the D3515-041 Basket Lid Assembly or the D3516-041 Basket Base Assembly.



**D119-756-041
HELI-UTILITY-BASKET**



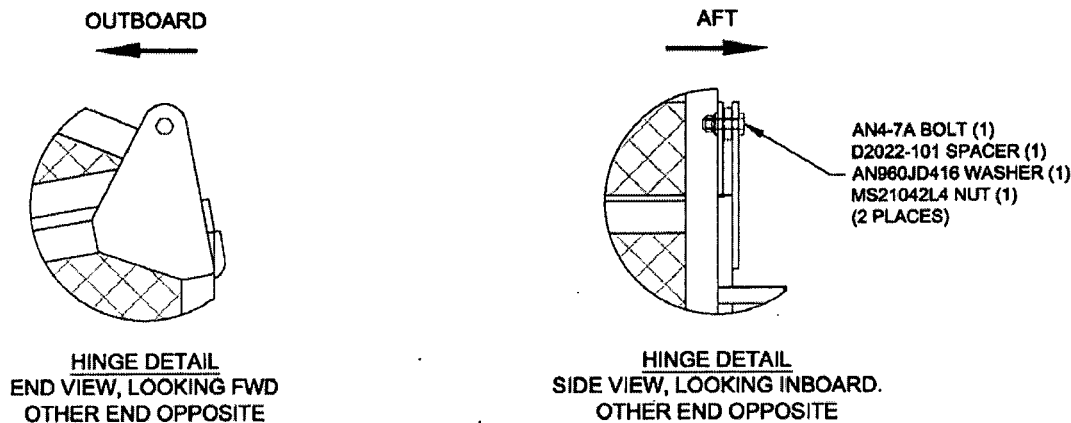
**VIEW C-C:
PROP ARM DETAIL**

**Figure 4 – Basket Replacement Parts
(D119-756-041 Heli-Utility-Basket™)**

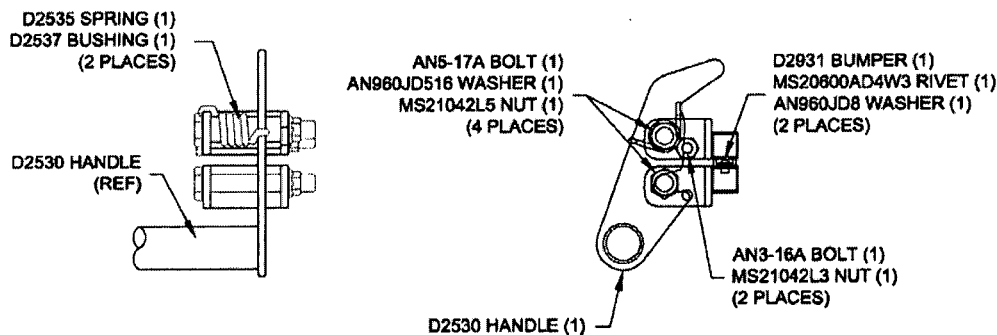
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31757

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Revision: **C**
Date: 06.10.23



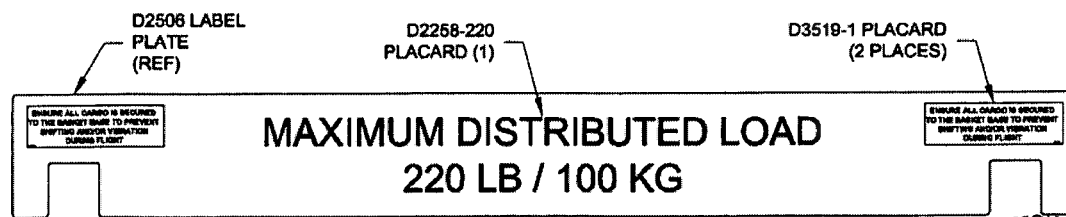
DETAIL M: HINGE



SPRING DETAIL

LATCH DETAIL

DETAIL N: HANDLE WELDMENT



VIEW Q-Q: PLACARDS
ONLY PLACARDS AND
LABEL PLATE SHOWN

Figure 5 – Basket Replacement Parts & Placards
(D119-756-041 Heli-Utility-Basket™)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31751

Date: Thursday, 4/12/2007 9:00:33 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET LID ASS'Y (A119)
Job Number	: 31751A		
Estimate Number	: 12445		
P.O. Number	: <i>PIA</i>	Part Number	: D3515041
This Issue	: 4/12/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D3515 REVA
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : LARGE FAB ASSY	Drawing Revision	: A
Previous Run	: 31750A	Material	: <i>PIA</i>
Written By	:	Due Date	: 5/30/2007 Qty: 1 Um: Each
Checked & Approved By	: <i>07.04.12</i>		
Comment	: EST rev. A 06.06.05 Preliminary EC est B 07.04.09 revA dwg EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10	D22321	Hinge
----	--------	-------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Basket Hinge

Batch: *B29535**07/05/10*

20	D31663	Basket Hoop
----	--------	-------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Basket Hoop

Batch: *B31118**07/05/10*

30	D23271	Spacer Bushing
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Spacer Bushing

Batch: *B28334**07/05/10*

40	D2506	Placard
----	-------	---------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Placard

Batch: *B30548**07/05/10*

50	D2581	Mounting Bracket
----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Mounting Bracket

Batch: *B30552**07/05/10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:00:33 AM

-User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 31751A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

M304TS0750W065

304 SQ Tube.75x.75x.065W



Comment: Qty.: 43.5750 f(s)/Unit Total : 43.5750 f(s)

AISI 304 SQ Tube.75x.75x.065W

Batch: M104307

07/05/10

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Cut rib D3515-1 (2) as per dwg D3516

2-Cut rib D3515-3 (2) as per dwg D3516

3-Cut rib D3515-5 (6) as per dwg D3516

4-Cut rib D3515-7 (3) as per dwg D3516

5-Cut Rib (4) D2236 from D3166-3 per dwg D2236

07/05/10

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Weld assembly as per dwg D3515

07/05/10

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-14 (1)

10.0

M304EX07516F

Expanded Metal Flat Stair



Comment: Qty.: 21.0000 sf(s)/Unit Total : 21.0000 sf(s)

Expanded Metal Flat Stainless steel

Batch: M104218

07/05/14 (2)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

07/05/16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 2 Date: 07/05/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Drawing Name: BASKET LID ASS'Y (A119)

Job Number: 31751A

Part Number: D3515041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-05-17 (C)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-05-17 (1)

14.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M 103706
wing walk - m103707

FH/m.h 07/05/18 (1)
WFO 07-05-17 (1)

15.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

m107/05/17 (1)

16.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

m107/05/17

17.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/05/18 (1)

Job Completion



07-05-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



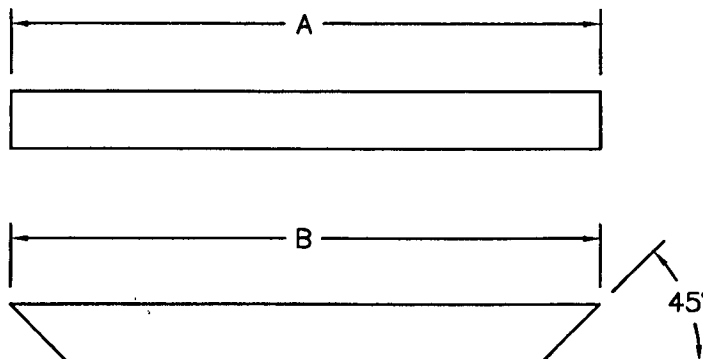
DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 1 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE NTS
A	06.05.05	NEW ISSUE	

RELEASED

06.11.17 *[Signature]*

PARTS LIST FOR D3515-041 BASKET LID ASSEMBLY

PART NO	QUANTITY	LENGTH	LENGTH	DESCRIPTION
		A	B	
D3515-1	2	—	25.50	RIB
D3515-3	2	—	101.30	RIB
D3515-5	6	33.84	—	RIB
D3515-7	3	30.63	—	RIB
D2232-1	2	N/A	N/A	HINGE PLATE
D2236	4	N/A	N/A	RIB
D2327-1	2	N/A	N/A	BUSHING
D2506	1	N/A	N/A	LABEL PLATE
D2581	2	N/A	N/A	MOUNTING BRKT



D3515-1/-3/-5/-7

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
(REF. DART SPECS. M304TS0.750W.065)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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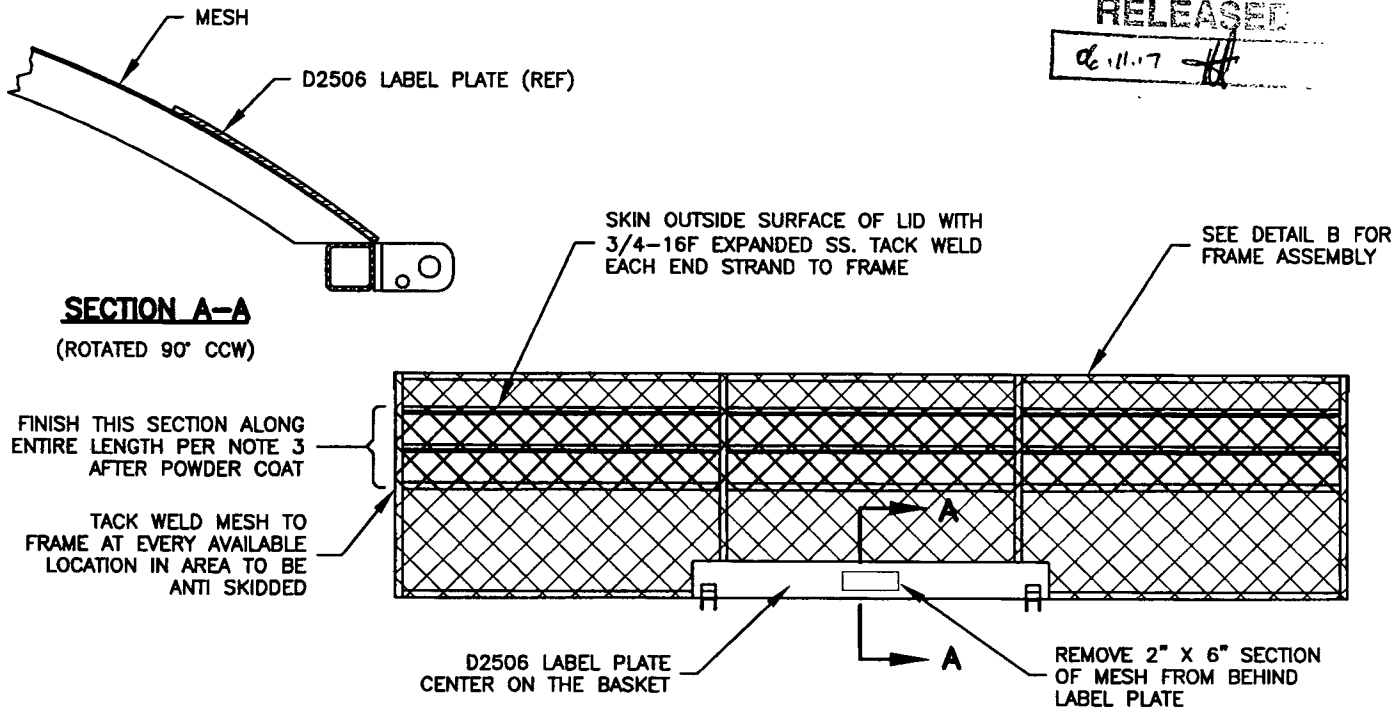
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DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DATE		D3515	SHEET 2 OF 4
06.05.05		TITLE	SCALE
		BASKET LID ASSEMBLY (A119)	1:20

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06.11.07



D3515-041 BASKET LID ASSEMBLY

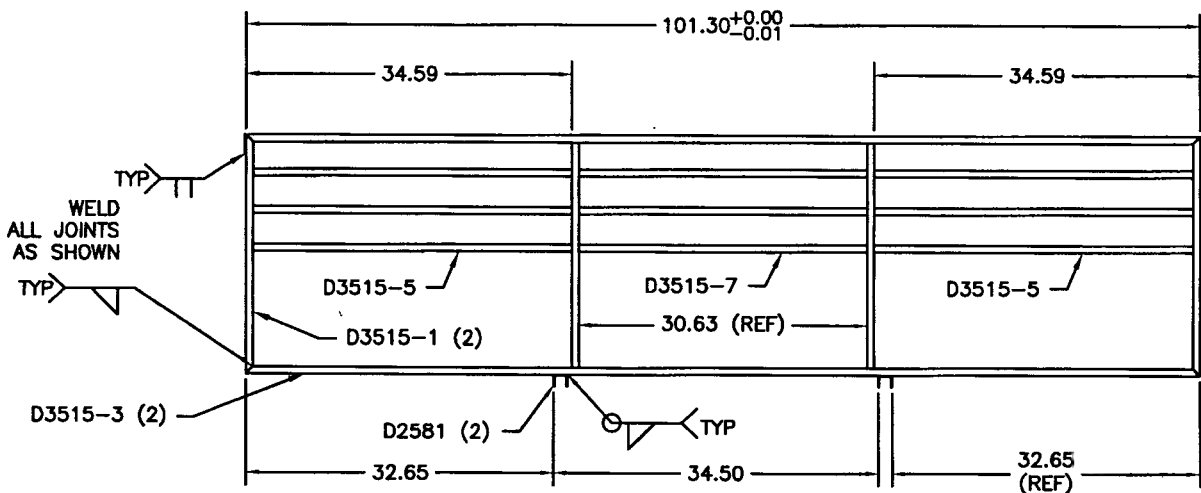
- 1) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) SPRAY PAINT BLACK INSIDE SURFACE
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACE PER DART QSI 005 4.4
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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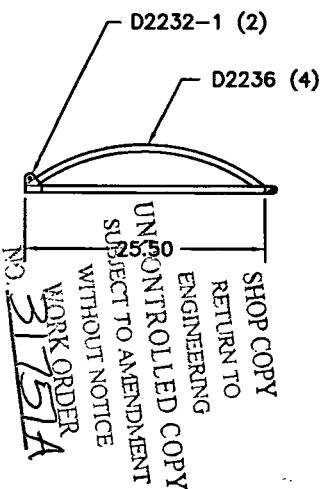
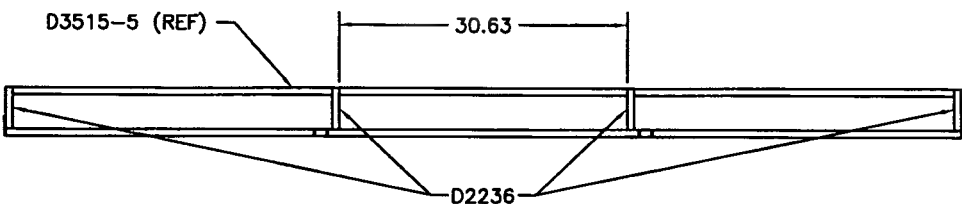
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAMKESBURY, ONTARIO, CANADA	REV. A
CHECKED	APPROVED	DRAWING NO. D3515	SHEET 3 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:20



DETAIL B

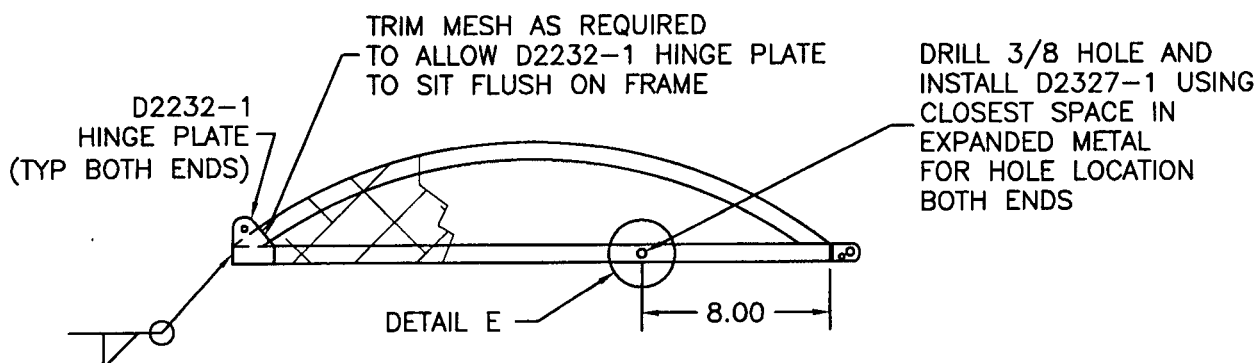
FRAMEWORK SHOWN FOR CLARITY
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES



RELEASED
06.11.17

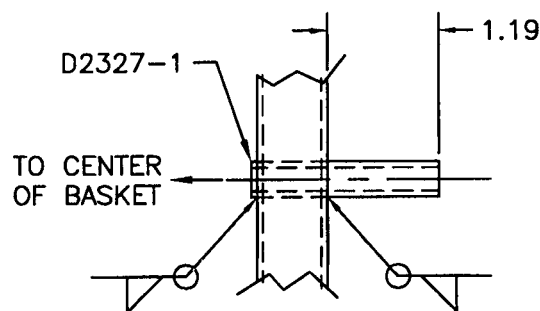


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3515	REV. A SHEET 4 OF 4
DATE 06.05.05		TITLE BASKET LID ASSEMBLY (A119)	SCALE 1:8

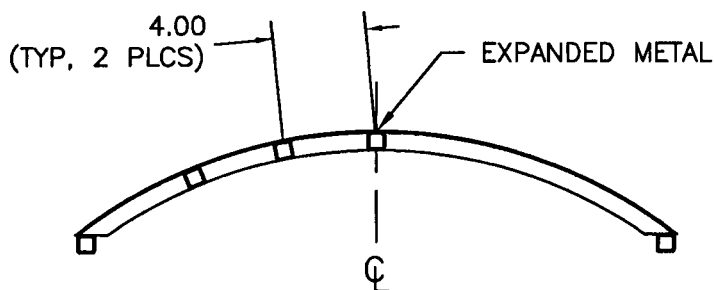


SECTION C-C SIMILAR BOTH END RIBS

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DETAIL E



SECTION D-D SAME BOTH CENTER RIBS

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Date: Thursday, 4/12/2007 9:00:56 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET BASE ASS'Y (A119)
Job Number	: 31751B		
Estimate Number	: 12431		
P.O. Number	: <u>N/A</u>	Part Number	: D3516041
This Issue	: 4/12/2007	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3516 REV.B
First Issue	: <u>N/A</u>	Project Number	: N/A
Previous Run	: 31750B	Drawing Revision	: B
	Type : LARGE FAB ASSY	Material	: <u>N/A</u>
Written By	:	Due Date	: 5/30/2007
Checked & Approved By	:	Qty:	1 Um: Each
Comment	: EST rev. A 06.05.31 Preliminary EC EST rev. A 06.07.27 updated EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

10	D34421	Shim
----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Shim

Batch: B 30564

A 07/05/11

20	D2581	Mounting Bracket
----	-------	------------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Mounting Bracket

Batch: B 30552

A 07/05/11

30	D351611	CLEVIS
----	---------	--------



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)
 CLEVIS

batch: B29572 ④B31800 ②

A 07/05/11

40	D351613	CLEVIS
----	---------	--------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
 CLEVIS

batch: B29573 ③B 31801 ①

A 07/05/11

50	D23273	Spacer Bushing
----	--------	----------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Spacer Bushing

Batch: B28597

A 07/05/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:00:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31751B

Part Number: D3516041

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

6.0	D22323	Basket Hinge
-----	--------	--------------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
Basket Hinge
Batch: B30873

M07/05/11

7.0	D31661	Basket Hoop
-----	--------	-------------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)
RIB
Batch: B31425

M07/05/11

8.0	M304TS0750W065	304 SQ Tube.75x.75x.065W
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Comment: Qty.: 53.1825 f(s)/Unit Total : 53.1825 f(s)
AISI 304 SQ Tube.75x.75x.065W
Batch: M104307

M07/05/11

9.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Cut rib D3516-1 as per dwg D3516

2-Cut rib D3516-3 as per dwg D3516

3-Cut rib D3516-5 as per dwg D3516

4-Cut rib D3516-7 as per dwg D3516

5-Cut rib D3516-9 from D3166-1 (4)

M07/05/11

10.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
------	-------------	------------------------------



Comment: LARGE FABRICATION RESOURCE 1
1-Weld assembly as per dwg D3516

M07/05/11

11.0	QC5	INSPECT WORK TO CURRENT STEP
------	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

PD 07-05-140

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:00:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31751B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 60.0000 sf(s)/Unit Total : 60.0000 sf(s)
Expanded Metal Flat Stainless steel
Batch: M04218

07/05/14 (C)

13.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1
1-Cut expanded metal for base as per dwg D3516

2-Cut expanded metal for base ends as per dwg D3516

3-Weld expanded metal to base as per dwg D3516

07/05/16

14.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-05-17 (D)

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PD 07-05-17 (D)

16.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M103706

07-05-18 (D)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1
Wing Walk as per Dwg D3515 and QSI 005 4.4 and spay paint as per Dwg
Wing Walk: _____
Black Spray Paint: _____

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

07/05/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: 12 Date: 2105/18
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 4/12/2007 9:00:56 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASS'Y (A119)

Job Number: 31751B

Part Number: D3516041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *GA*

ml 02/05/17

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
RD 0705/18

Job Completion



U 0705.18

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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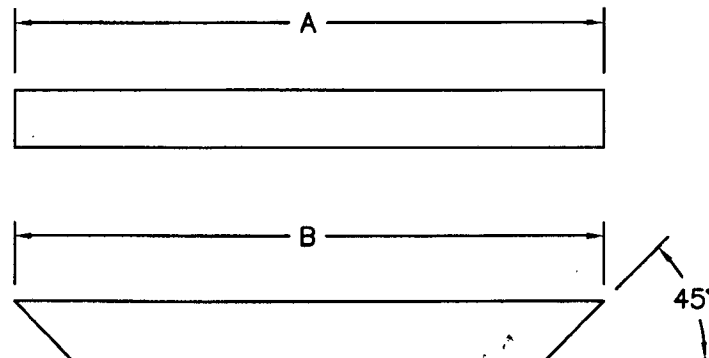
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

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06.11.28 *[Signature]***PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

B {

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING (REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

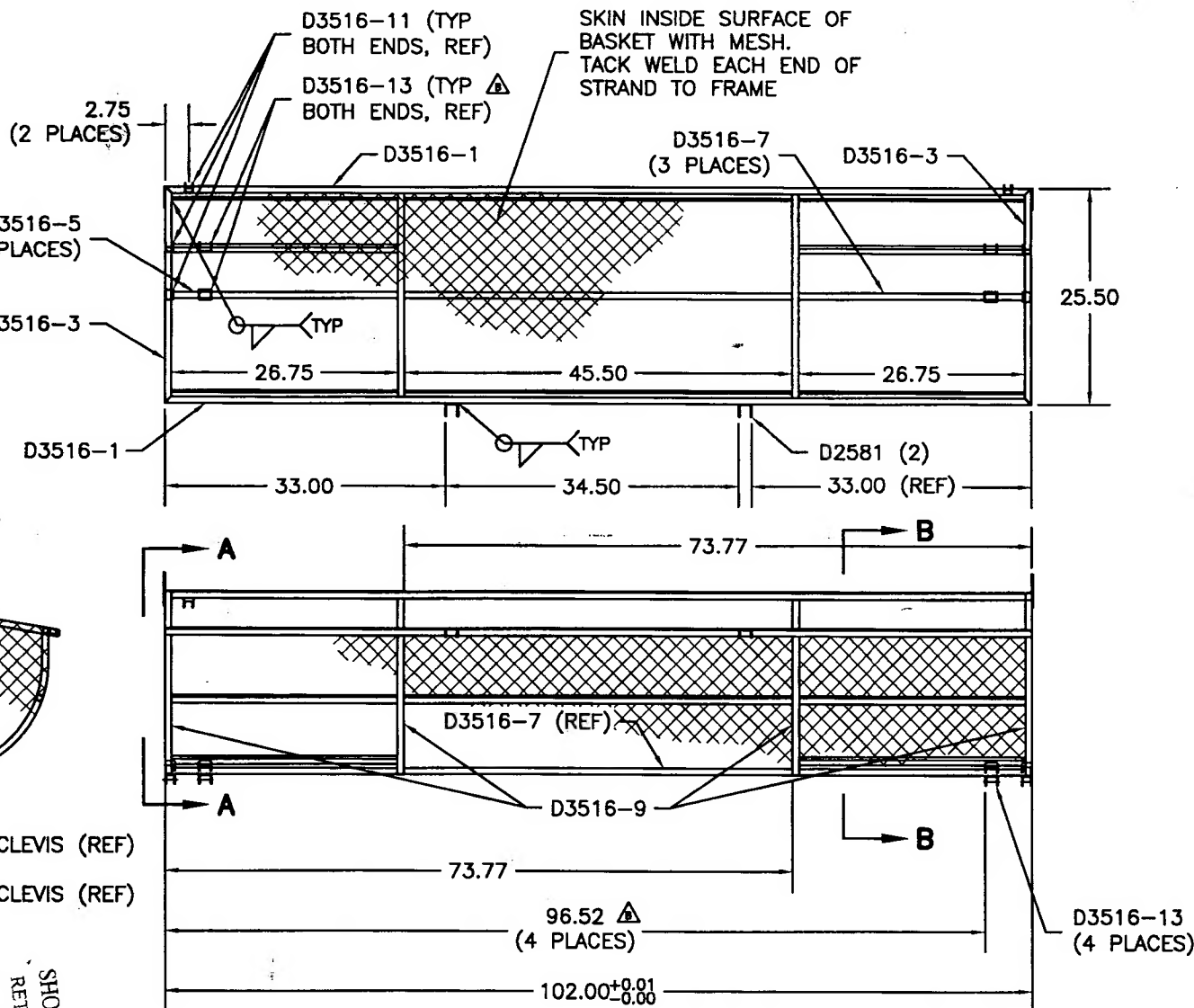
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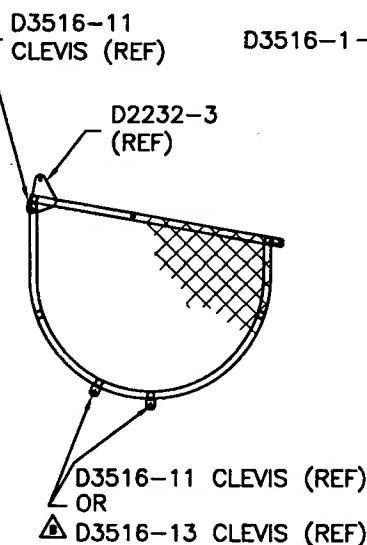
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06.07.25	D3516	SHEET 2 OF 5
	TITLE	SCALE
	BASKET BASE ASSEMBLY (A119)	1:20



D3516-041 BASKET BASE ASSEMBLY

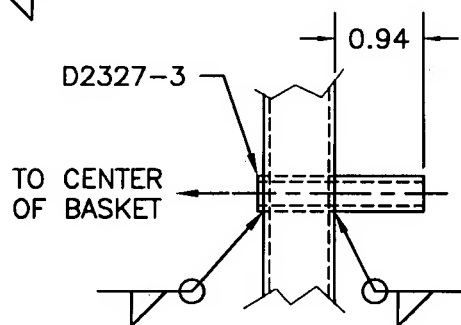
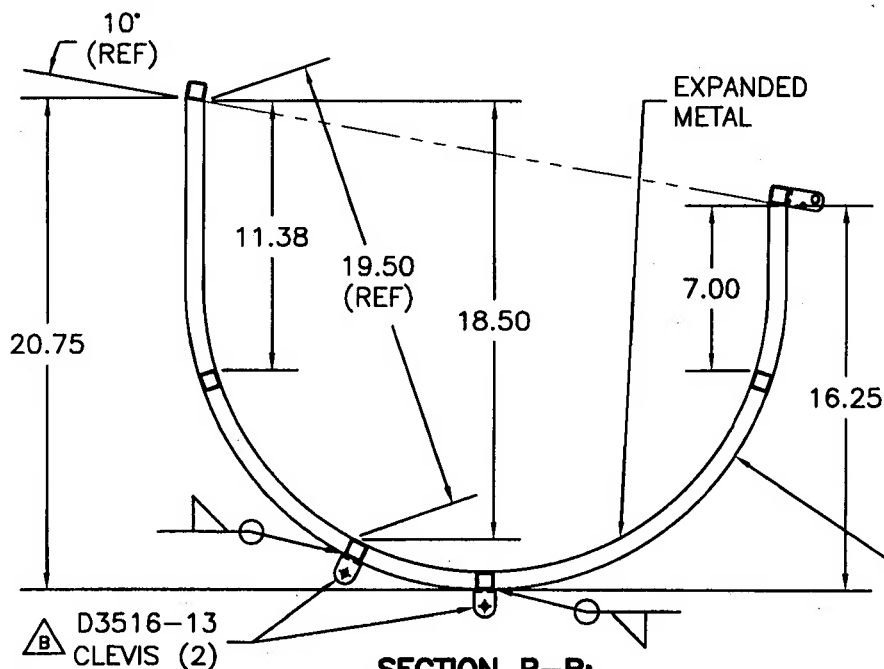
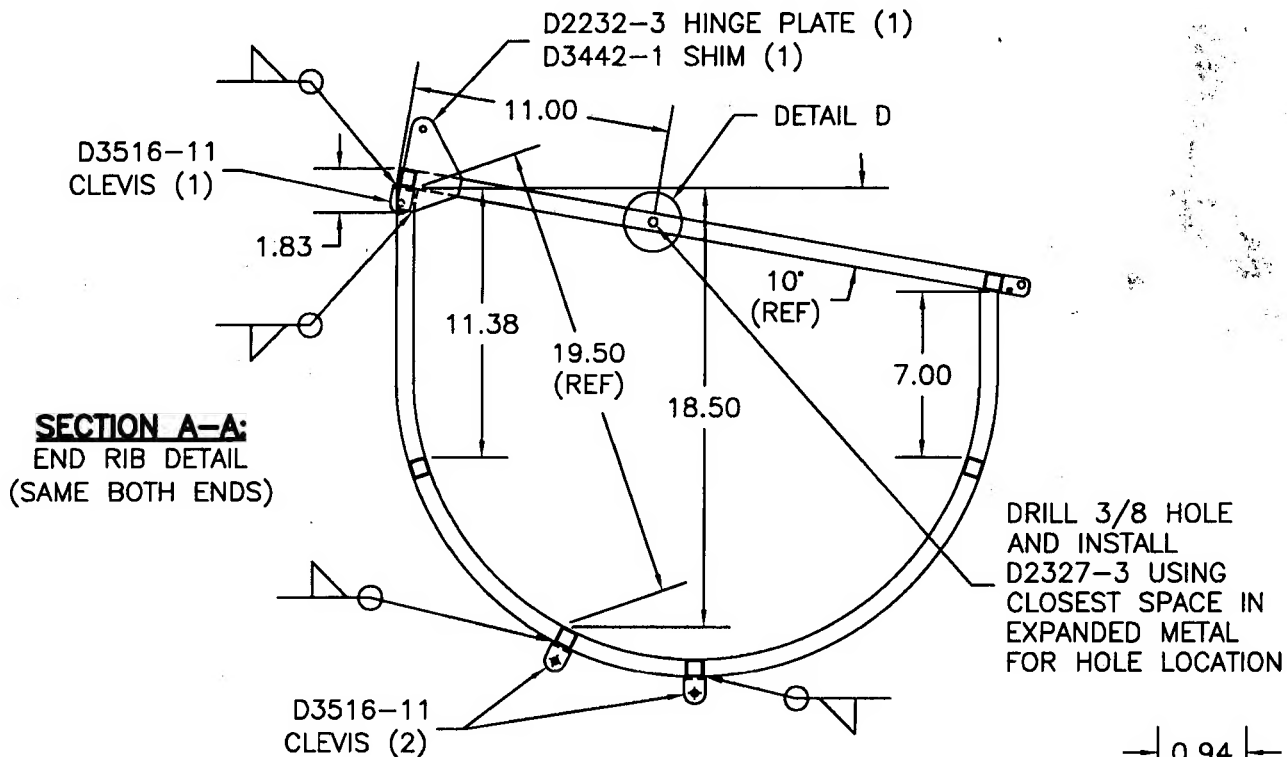
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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:8

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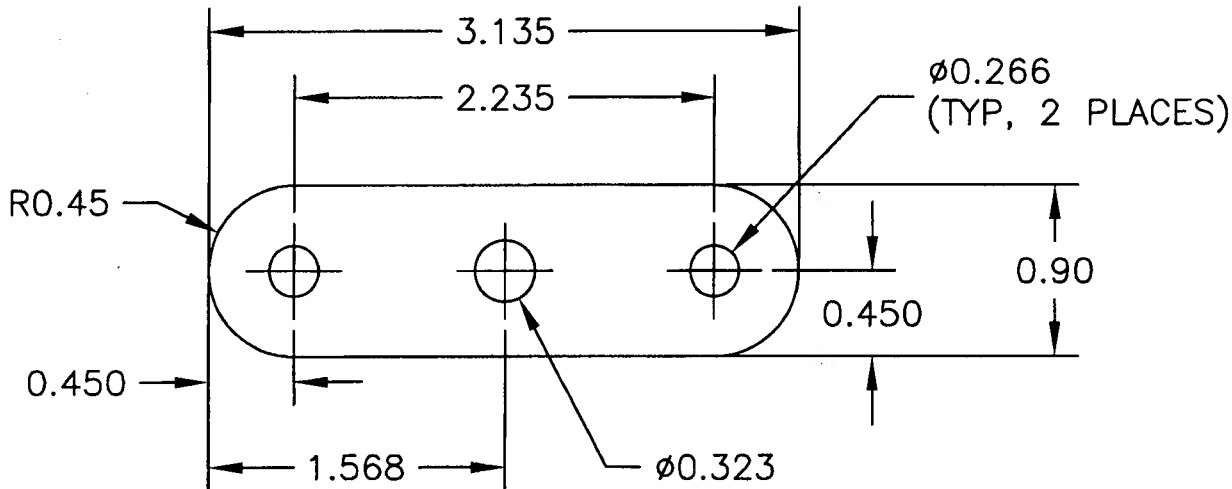
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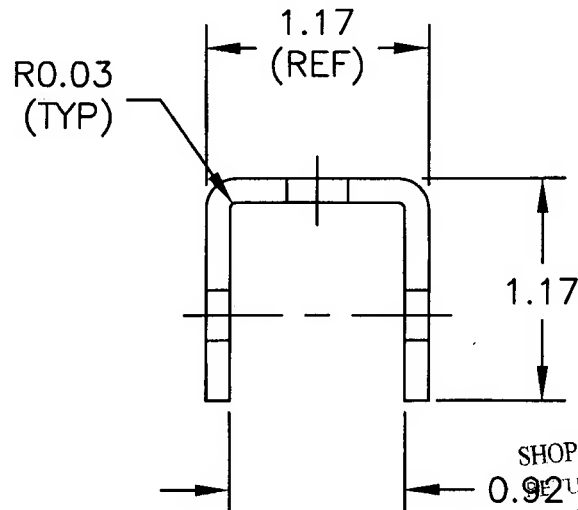
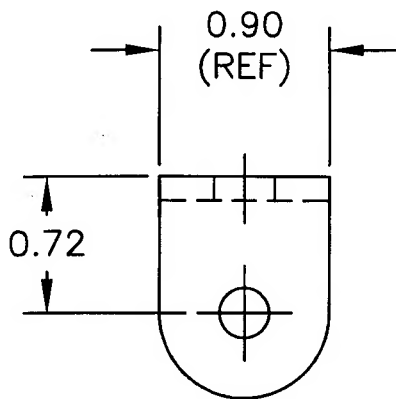
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CHECKED <i>PH</i>	APPROVED <i>H</i>	DRAWING NO. D3516	REV. B SHEET 4 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1

**D3516-11F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

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06.11.28 *H*

**D3516-11 CLEVIS BENDING DETAIL**

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3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

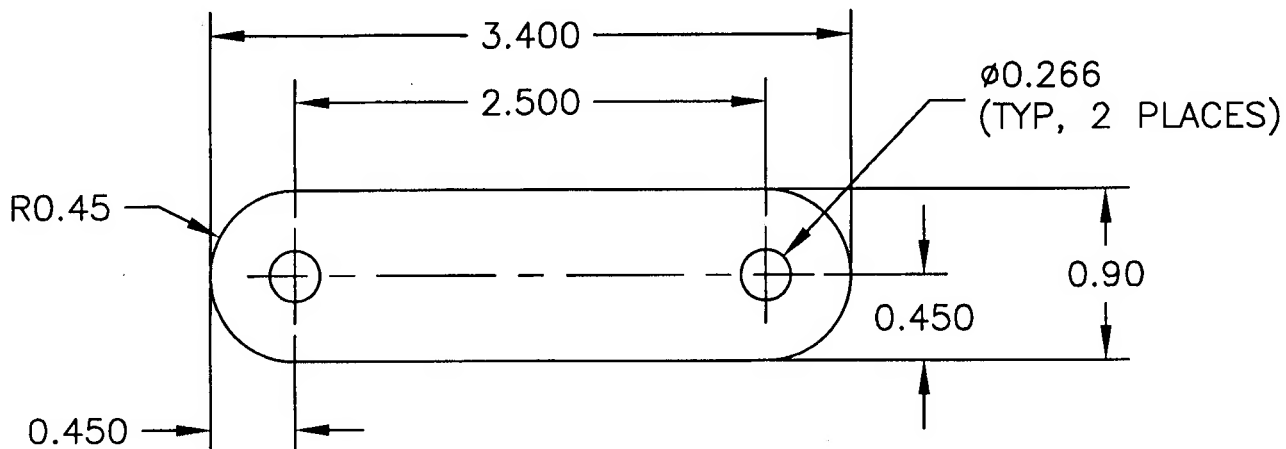
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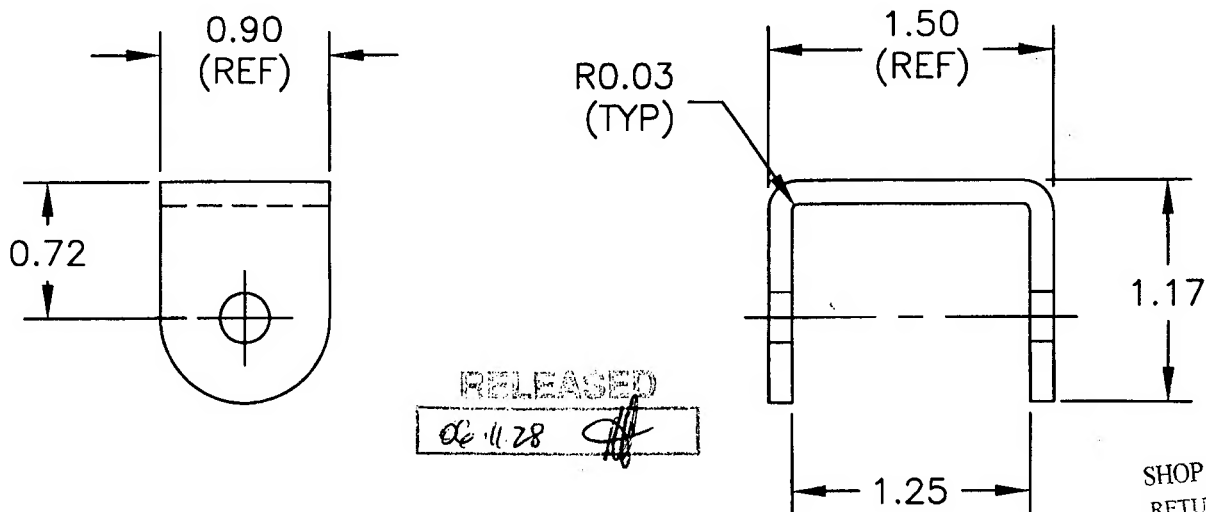


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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



D3516-13 CLEVIS BENDING DETAIL

- 1) MATERIAL: MAKE FROM D3516-13F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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